

Work Order ID 159886

Wednesday, April 19, 2017 1:01:50 PM

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Page 1

Item ID: 647.7303 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: EC135 T1/P1 Cable Cutters (Removable Provisions Only)
Start Date: 4/19/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/20/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULED/AOG
Approvals: Process Plan:  Date: APR 19 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
MPP-195	N/C	APR 19 2017	DAS 6 9-89						
100	Document Control	0.00							
100	DOCUMENT CONTROL					DAS 27 9-89			
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP 647.7303 (MPP-195)					APR 19 2017			
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control						DAS 27 9-89			

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Item ID: 647.7303 **Accept** ***N900040100*** **Setup Start** ***NS1***
Revision ID: **Stop** ***NS2***
Item Name: EC135 T1/P1 Cable Cutters (Removable Provisions Only)
Start Date: 4/19/2017 **Start Qty:** 1.00 ***1*** **Cust Item ID:**
Required Date: 4/20/2017 **Req'd Qty:** 1.00 ***1*** **Customer:**
Reference: SCHEDULED/AOG

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** ***NR1***
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP 647.7303 Location: _____								
	sold								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.10							
Quality Control									

DAS
27
9-89
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DAS
21
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APR 20 2017

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21
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Work Order ID: 159886

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Parent Item: 647.7303

647 7303

Parent Item Name: EC135 T1/P1 Cable Cutters (Removable Provisions Only)

Start Date: 4/19/2017

Required Date: 4/20/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.10.05 NEW ISSUE DD VERF:JLM
REV:B 16.11.24 NEW ISSUE DD VERF:JFS
17.01.24 PER MPP-195 N/C DD VERF:JLM
IPP
IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.7401 *647 7401* Upper Cutter Assembly		Manufactured	No			110	Each	1.0000	1	1		APR 19 2017	DAS 28 9-89
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					cck029			1					
					137316			1					
647.7501 *647 7501* Lower Cutter Assembly		Manufactured	No			110	Each	0.0000	1	1		APR 19 2017	DAS 28 9-89
647.1701 *647 1701* Skid Deflector Assembly		Manufactured	No			110	Each	4.0000	2	2		APR 19 2017	DAS 28 9-89
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					CCK033			4					
					138396			2					
					141079			2					
647.7702 *647 7702* Strut Assembly		Manufactured	No			110	Each	8.0000	2	2		APR 19 2017	DAS 28 9-89
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					CCK076			8					
					154420			6					
					154668			2					

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Work Order ID: 159886

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Parent Item: 647.7303

647 7303

Parent Item Name: EC135 T1/P1 Cable Cutters (Removable Provisions Only)

Start Date: 4/19/2017

Required Date: 4/20/2017

Start Qty: 1.00

Required Qty: 1.00

647.7701 Manufactured No

110 Each 4.0000 2 2

647 7701

Strut Assembly

**

APR 19 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

CCK114

4

153191

1

154421

3

647.0112 Manufactured No

110 Each 7.0000 4 4

647 0112

Strut Bracket

**

APR 19 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

CCK106

7

155480

7

647.2511 Manufactured No

110 Each 0.0000 2 2

647 2511

Nut

**

159807

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28
9-89

601.3011 Manufactured No

110 f 45.9000 1.4 1.4

601 3011

P-Seal

**

APR 19 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

CCK095

45.8

91709

45.8

CCK099

0.1

M130388

0.1

CUT AT 16.00"

MS21266-2N Purchased No

110 Each 38.0000 1 1

MS21266-2N

Grommet

**

APR 19 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

ST294

38

123900

38

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Work Order ID: 159886

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Parent Item: 647.7303

647 7303

Parent Item Name: EC135 T1/P1 Cable Cutters (Removable Provisions Only)

Start Date: 4/19/2017

Required Date: 4/20/2017

Start Qty: 1.00

Required Qty: 1.00

AN44-5A Purchased No

110 Each 19.0000 2 2

AN44-5A

Eyebolt

**

APR 19 2017

Location

Loc Qty

Loc Code

ST339

19

m136866

7

m137075

12

AN44-12A Purchased No

110 Each 7.0000 2 2

AN44-12A

Eyebolt

**

APR 19 2017

Location

Loc Qty

Loc Code

ST339

7

m136579

2

m137280

5

AN665-34R Purchased No

110 Each 10.0000 4 4

AN665-34R

Clevis

**

APR 19 2017

Location

Loc Qty

Loc Code

ST330

10

153852

10

AN3-11A Purchased No

110 Each 304.0000 4 4

AN3-11A

Bolt

**

APR 19 2017

Location

Loc Qty

Loc Code

over003

100

m136192

100

ST349

204

153855

204

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Work Order ID: 159886

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Parent Item: 647.7303

647 7303

Parent Item Name: EC135 T1/P1 Cable Cutters (Removable Provisions Only)

Start Date: 4/19/2017

Required Date: 4/20/2017

Start Qty: 1.00

Required Qty: 1.00

AN4C7A	Purchased	No	110	Each	36.0000	4	4
--------	-----------	----	-----	------	---------	---	---

AN4C7A

BOLT

**

Location

Loc Qty

Loc Code

ST345

36

m136295

36

NAS6603-12

Purchased No

110 Each

119.0000

4

4

NAS6603-12

Bolt

**

Location

Loc Qty

Loc Code

st552

119

123900

84

m136301

35

NAS6603-16

Purchased No

110 Each

64.0000

4

4

NAS6603-16

Bolt

**

Location

Loc Qty

Loc Code

st552

64

153860

14

m133523

50

NAS6604-66

Purchased No

110 Each

62.0000

4

4

NAS6604-66

Bolt

**

Location

Loc Qty

Loc Code

ST553

62

124328

20

M130388

42

MS21042-08

MS21042L08

Purchased No

110 Each

0.0000

6

6

MS21042-08

USE MS21042L08

**

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Work Order ID: 159886

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Parent Item: 647.7303

647 7303

Parent Item Name: EC135 T1/P1 Cable Cutters (Removable Provisions Only)

Start Date: 4/19/2017

Required Date: 4/20/2017

Start Qty: 1.00

Required Qty: 1.00

MS21042-3 MS21042L3 Purchased No

110 Each 0.0000 4 4

MS21042-3

Nut

MS21042L4 Purchased No

110 Each 843.0000 8 8

MS21042L4

Nut

Location

Loc Qty

Loc Code

FP001

10

m133363

10

GA

154

m135058

154

ST303

679

m136986

179

m137166

500

AN316C4R Purchased No

110 Each 25.0000 4 4

AN316C4R

Nut, Jam

Location

Loc Qty

Loc Code

ST331

25

153850

25

MS27039-08-13 Purchased No

110 Each 314.0000 4 4

MS27039-08-13

Screw

Location

Loc Qty

Loc Code

ST278

314

153849

314

DAS 28 9-89

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DAS 28 9-89

AS 28 9-89

APR 19 2017

DAS 28 9-89

AS 28 9-89

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DAS 28 9-89

AS 28 9-89

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Parent Item: 647.7303

647 7303

Parent Item Name: EC135 T1/P1 Cable Cutters (Removable Provisions Only)

Start Date: 4/19/2017

Required Date: 4/20/2017

Start Qty: 1.00

Required Qty: 1.00

MS27039-08-16

Purchased

No

110

Each

75.0000

2

2

MS27039-08-16

SCREW PAN HD

**

DAS
28
9-89

Location

Loc Qty

Loc Code

CA

48

112466

48

ST278

27

M130388

27

APR 19 2017

DAS
6
9-89

DAS
27
9-89

NAS1149FN832P

Purchased

No

110

Each

694.0000

12

12

NAS1149FN832P

Washer

**

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

627

M135058

232

M136182

40

M136866

355

ST263

67

M136866

67

APR 19 2017

DAS
6
9-89

DAS
27
9-89

NAS1149F0332P

Purchased

No

110

Each

1,436.000

12

12

NAS1149F0332P

Washer

**

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

275

m133709

275

ST262

1161

m136835

8

m137075

1153

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27
9-89

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Work Order ID: 159886

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Parent Item: 647.7303

647 7303

Parent Item Name: EC135 T1/P1 Cable Cutters (Removable Provisions Only)

Start Date: 4/19/2017

Required Date: 4/20/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0432R

Purchased

No

110

Each

1,037.000

8

8

NAS1149C0432R

WASHER

**

APR 19 2017

DAS
6
9-89

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

357

m134676

357

ST266

680

m136182

5

m136986

675

8

NAS1149F0532P

Purchased

No

110

Each

1,603.000

2

2

NAS1149F0532P

Washer

**

APR 19 2017

DAS
6
9-89

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST260a

600

m133725

600

ST262

1003

18057

1003

2

601.2045

Purchased

No

110

Each

11.0000

1

1

601 2045

RTV (LOCTITE 598) McMaster p/n: 6641A41

**

APR 19 2017

DAS
6
9-89

DAS
28
9-89

10/18

DAS
27
9-89

Location

Loc Qty

Loc Code

CCK096

3

m136902

3

GA

8

m134260

8

1

NAS1149F0463P

Purchased

No

110

Each

398.0000

8

8

NAS1149F0463P

Washer

**

APR 19 2017

DAS
6
9-89

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST262

398

m127832

398

8

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SUBJECT:
Manufacturing Process Procedure
EC-135 CCK Configuration Management

DOCUMENT NO:
MPP-195
Rev. N/C
12/15/16

5.0 BILLS OF MATERIAL, FIXED/REMOVABLE METHOD

The drawing 647.7300 shows the top assembly bills of material for each major configuration (647.7301, 647.7304, and 647.7307). The following tables separate the top assemblies into the fixed and removable provisions kit as described above. The find numbers coincide with the drawing callouts. Material and Specification are provided as well. The major configurations are provided for clarity.

Table 18: T1/P1 Cable Cutters Kits

7303	7302	7301	FIND #	PART #	DESCRIPTION	MATERIAL	SPEC
1		1	1	647.7401	UPPER CUTTER ASSY		
1		1	2	647.7501	LOWER CUTTER ASSY		
2		2	3	647.1701	SKID DEFLECTOR ASSY		
	1	1	4	647.1601	WIPER DEFLECTOR ASSY, AFT		
	1	1	5	647.1610	WIPER DEFLECTOR, FWD		
	1	1	6	647.1913	TEE		
	1	1	7	647.1915	SUPPORT ANGLE		
	1	1	8	647.1814	GUSSET, LH		
	1	1	9	647.1815	GUSSET, RH		
2		2	10	647.7702	STRUT ASSY		
2		2	11	647.7701	STRUT ASSY		
	1	1	12	647.1818	NOSE DOOR SPACER		
	1	1	13	647.1810	NOSE DOOR DOUBLER		
4		4	14	647.0112	STRUT BRACKET		
	2	2	15	647.7910	ANGLE BACKET		
	2	2	16	647.7911	BRACKET		
	4	4	17	647.7912	CLIP		
	2	2	18	647.7913	DOUBLER		
	1	1	19	647.7914	BRACKET		
	1	1	20	647.7915	BRACKET		
	2	2	21	647.7916	BRACKET		
	1	1	22	647.7917	BRACKET		
	1	1	23	647.7918	BRACKET		
	1	1	24	647.7819	CROSS BRACKET FWD		
	1	1	25	647.7820	CROSS BRACKET AFT		
	1	1	26	647.7818	MOUNTING CHANNEL		
	1	1	27	647.7821	EYE BOLT FITTING LH		
	1	1	28	647.7822	EYE BOLT FITTING RH		

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Manufacturing Process Procedure
EC-135 CCK Configuration Management

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7303	7302	7301	FIND #	PART #	DESCRIPTION	MATERIAL	SPEC
	1	1	29	647.1914	BRACKET		
	1	1	30	647.1602	DOUBLER ASSY		
	2	2	31	647.1811	SPACER		
	13	13	32	647.1812	SHIM		
	4	4	33	647.2510	SLEEVE		
2	2	4	34	647.2511	NUT		
	1	1	35	647.3201	GROUNDING CABLE ASSY		
A/R	A/R	A/R	36	601.3011	P-SEAL		
1	1	1	37	601.3007	GROMMET	MS21266-2N	
2		2	38	601.3121	EYE BOLT	AN44-5A	
2		2	39	601.3120	EYE BOLT	AN44-12A	
4		4	40	601.3119	CLEVIS		
	2	2	41	601.3006	CAMLOC RECEPTACLE		
	2	2	42	601.3005	CAMLOC RETAINER		
	2	2	43	601.3004	CAMLOC STUD		
	12	12	44	600.0795	NUTPLATE	MS21047-3	
	2	2	45	601.2823	BOLT	AN3-4A	
4		4	46	601.2826	BOLT	AN3-11A	
	1	1	47	601.1324	BOLT	AN4CH6A	
4		4	48	601.2669	BOLT	AN4C7A	
4		4	49	601.1500	BOLT	NAS6603-12	
4		4	50	601.3130	BOLT	NAS6603-16	
4		4	51	601.3002	BOLT	NAS6604-66	
6	1	7	52	601.2973	LOCKNUT	MS21042-08	
4	30	34	53	601.2943	LOCKNUT	MS21042-3	
8		8	54	601.3209	LOCKNUT	MS21042L4	
4		4	55	601.3128	NUT	AN316C4R	
	18	18	56	647.8510	INSERT		
	4	4	57	647.8511	INSERT		
	2	2	58	647.8512	INSERT		
	4	4	59	601.3127	LOCKNUT	MS21042L5	
	1	1	60	601.2525	SCREW	MS27039-0807	
4		4	61	601.2988	SCREW	MS27039-0813	
2		2	62	601.3137	SCREW	MS27039-816	
	3	3	63	601.2198	SCREW	MS27039-1-07	
	12	12	64	601.3069	SCREW	MS27039-1-09	
	6	6	65	601.1365	SCREW	MS27039-1-10	
	2	2	66	601.1953	SCREW	MS27039-1-12	

REFERENCE ONLY



SUBJECT:
Manufacturing Process Procedure
EC-135 CCK Configuration Management

DOCUMENT NO:
MPP-195
Rev. N/C
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7303	7302	7301	FIND #	PART #	DESCRIPTION	MATERIAL	SPEC
	4	4	67	601.1622	SCREW	MS27039-1-14	
	1	1	68	601.3012	SCREW	MS27039-1-15	
	4	4	69	601.2637	SCREW	MS27039-1-16	
	2	2	70	601.1954	SCREW	MS27039-1-17	
	6	6	71	601.2829	SCREW	MS24694S54	
	3	3	72	601.2999	SCREW		
	24	24	73	601.2207	NUTPLATE RIVET	CCR264SS-3-03	
	4	4	74	601.1983	NUTPLATE RIVET	CCR274SS-3-03	
	4	4	75	601.1604	CHERRY RIVET	CR3213-4-2	
	24	24	76	601.0790	CHERRY RIVET	CR3213-4-3	
	16	16	77	601.1915	CHERRY RIVET	CR3213-4-4	
	8	8	78	601.1183	CHERRY RIVET	CR3213-4-5	
	17	17	79	601.2991	CHERRY RIVET	CR3213-4-6	
	16	16	80	601.2020	CHERRY RIVET	CR3213-5-3	
	12	12	81	601.2481	CHERRY RIVET	CR3213-5-4	
	8	8	82	601.3216	CHERRY RIVET	CR3522-4-3	
	8	8	83	601.3215	CHERRY RIVET	CR3522-5-3	
	2	2	84	601.3136	CHERRY RIVET	CR3212-5-6	
12	2	14	85	601.2764	WASHER	NAS1149FN832P	
12	74	86	86	601.1607	WASHER	NAS1149F0332P	
8		8	87	601.3663	WASHER	NAS1149C0432R	
2	2	4	88	601.3126	WASHER	NAS1149F0532P	
	3	3	89	601.2375	WASHER		
	A/R	A/R	90	600.1012	SEALANT	PR-1425 CLASS B	
A/R		A/R	91	601.2045	RTV	LOCTITE 598	
	A/R	A/R	92	600.0991	MAGNOBOND 6398 PART B		
	A/R	A/R	93	600.0990	MAGNOBOND 6398 PART A		
	1	1	94	647.7919	SHIM		
8		8	95	601.1097	WASHER	NAS1149F0463P	
1		1	96	647.5701	GPS MOUNT KIT	FLAG NOTE 6	
			97	647.7823	CROSS BRACKET AFT		
			98	647.2114	UPPER U CHANNEL		
			99	647.1404	CUTTER ASSY (UPPER)		
			100	601.3962	SCREW	MS27039-0827	
			101	601.1541	LOCKNUT	MS21042L08	
	4	4	102	601.3212	CHERRY RIVET	CR3523-4-3	
	24	24	103	601.3213	CHERRY RIVET	CR3523-4-4	
	8	8	104	601.3214	CHERRY RIVET	CR3523-5-3	

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Item ID: 647.7303 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: EC135 T1/P1 Cable Cutters (Removable Provisions Only)

Start Date: 4/19/2017 Start Qty: 1.00 *1* Cust Item ID:

Required Date: 4/20/2017 Req'd Qty: 1.00 *1* Customer:

Reference: SCHEDULED/AOG

Approvals: Process Plan:  Date: APR 19 2017 Tooling: Date: Run Start *NR1*

QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
MPP-195	N/C	APR 19 2017							
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP 647.7303 (MPP-195)								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

CB

17-04-19

APR 19 2017